

[54] **PLASTICATING CONTROL APPARATUS
FOR INJECTION MACHINE**

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[57] **ABSTRACT**

A plasticating control apparatus for an in-line screw type injection machine, including a resin pressure sensor for detecting as an electrical signal pressure of a molten material at a distal end of a heating cylinder during plastication; means for directly converting the rotational speed of an electric motor to reciprocal movement of a hydraulic piston for driving a screw; and a control circuit for receiving the electrical signal from the resin pressure sensor and supplying the control signal to the electric motor in accordance with the electrical signal, the control signal supplied from the control circuit to the electric motor being adapted to control the rotational speed of the electric motor and hence a backward speed of the screw such that the pressure of the molten material at the distal end of the heating cylinder is not a negative pressure but substantially zero kg/cm².

9 Claims, 7 Drawing Figures

